

Date: Monday, 11/08/2008 10:20:19 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	STOP
<b>Job Number</b> :	41081		
<b>Estimate Number</b> :	10514		
<b>P.O. Number</b> :		<b>Part Number</b> :	D28051
<b>This Issue</b> :	11/08/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2805 REV. B
<b>First Issue</b> :	11/08/2008	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	35852	<b>Drawing Revision</b> :	B
	<b>Type</b> :	<b>Material</b> :	
	MACHINED PARTS	<b>Due Date</b> :	26/08/2008
<b>Written By</b> :		<b>Qty:</b>	40 Um: Each
<b>Checked &amp; Approved By</b> :	<u>NO 08.8.11</u>		
<b>Comment</b> :	Est: B 00.11.14 Revised Finishing step to Acid etch and Alodine EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1500X01500	6061-T6 Bar 1.50 x 1.50
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**Comment:** Qty.: 0.2756 f(s)/Unit Total: 11.0250 f(s)

6061-T6 Bar 1.5" x 1.5"

Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.5" x 1.5"

(M6061T6B1500X01500)

Batch: M107244

*not in computer*

2.0	BAND SAW	BAND SAW
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**Comment:** BAND SAW

Cut Bar: 3.150" Long +0.010/-0.030"

*J.L 08/08/25*

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA104 and Dwg D2805

2- Tumble and Deburr

Identify as D2805-1

*RP 08/09/06 M.A 08/09/05*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

*RP 08/09/06 M.A 08/09/05*

5.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

*RP 08/09/06 (40)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/08/2008 10:20:19 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STOP

Job Number: 41081

Part Number: D28051

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*JS*

*08-09-08*

*(40X)*

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

*M-H*

*08/09/08*

*(40X)*

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*ST 170 over stock*

*JS*

*08/09/08*

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/09/10*

Job Completion



*u 08/09/08*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 41081
<b>Description:</b> Stop		<b>Part Number:</b> D2805-1
<b>Inspection Dwg:</b> D2805 <b>Rev:</b> B		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.974	+/-0.010	2.975	✓			
0.240	+/-0.010	0.239	✓			
0.100 chamfer	+/-0.010	0.099	✓			
1.420	+/-0.001	1.421	✓			
1.125	+/-0.010	1.127	✓			
0.250	+0.005/-0.000	0.253	✓			
0.250	+/-0.010	0.247	✓			
1.500	+/-0.010	1.500	✓			
1.000	+/-0.010	1.000	✓			
0.875	+0.001/-0.000	0.875	✓			
0.438	+0.001/-0.000	0.439	✓			
Ø0.191	+0.005/-0.000	Ø0.193	✓			
2.689	+/-0.010	2.688	✓			

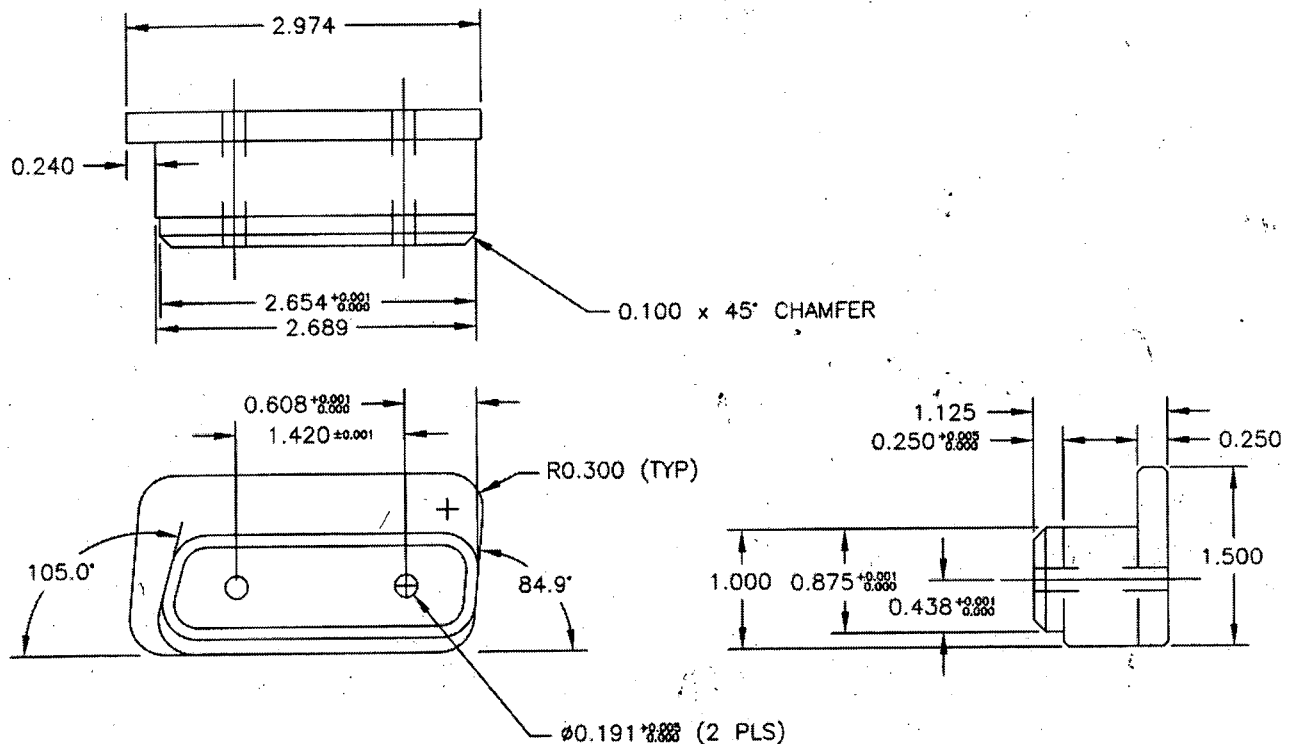
<b>Measured by:</b> M.A	<b>Audited by:</b> RQ	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 08/09/05	<b>Date:</b> 08/09/06	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	07.03.21	Dimensions added	KJ/JLM	BE



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2805	REV. B SHEET 1 OF 2
DATE 01.03.13		TITLE STOP	SCALE 2:3
A	00.10.31	NEW ISSUE	
B	01.03.13	ADD -3/-4	

RELEASED  
01.03.16 #



D2805-1 (SHOWN)  
D2805-2 (OPPOSITE)

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED.  
BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED.  
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER  
NO. 47081

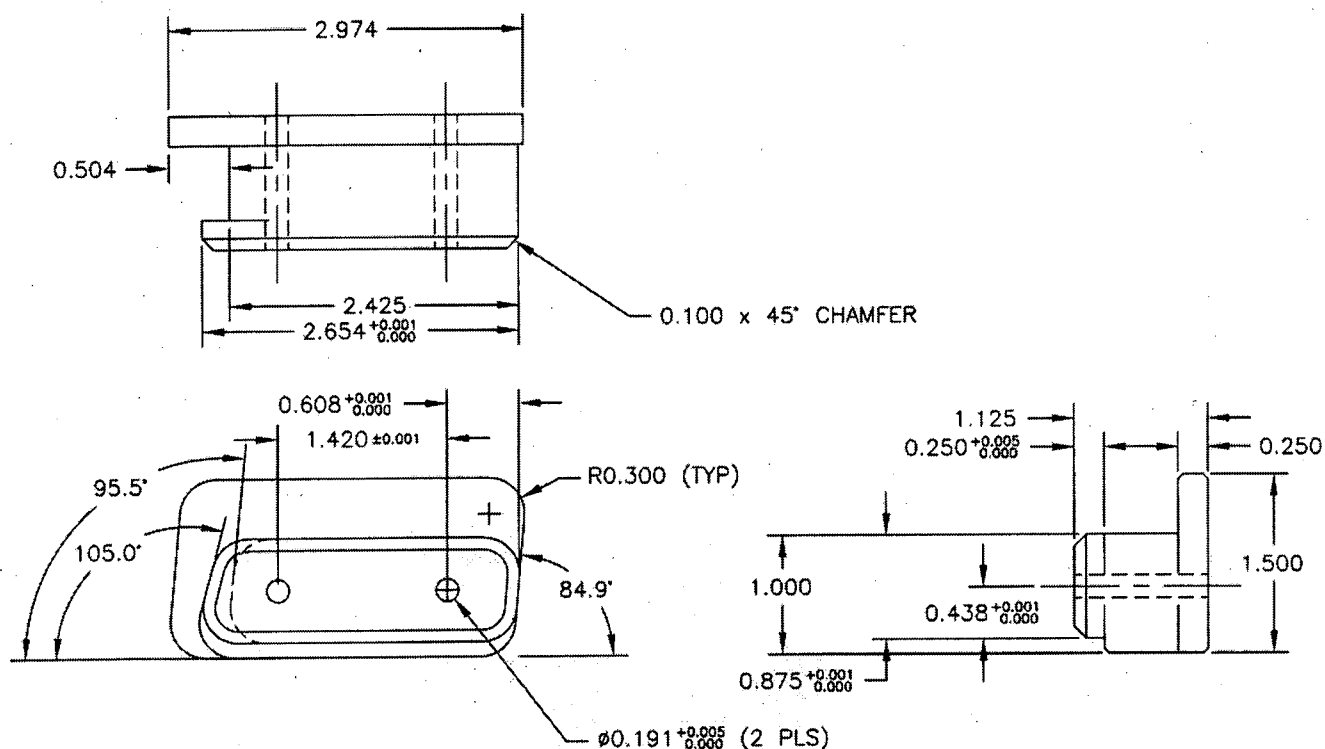
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DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2805	REV. B SHEET 2 OF 2
DATE 01.03.13		TITLE STOP	SCALE 2:3

RELEASED  
01.03.16



D2805-3 (SHOWN)  
D2805-4 (OPPOSITE)

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED.  
BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED.  
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11)  
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